

Date: Tuesday, 05/08/2008 8:56:33 AM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 40987	
Estimate Number : 13539	
P.O. Number :	Part Number : D38113
This Issue : 05/08/2008 S.O. No. :	Drawing Number : D3811-PREL Rev.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : PREL Rev.A 0810.07
Previous Run :	Material :
Written By : <u>08.08.05</u>	Due Date : 12/08/2008 Qty: 30 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 08-08-05 JLM Verified By:EC	

Additional Product

PRELIMINARY ISSUE

pt 08.03.20



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



30

Comment: Qty.: 0.0315 f(s)/Unit Total: 0.9450 f(s)

6061-T6 Round Bar .500"

Batch: 0105671

mmf 08/08/07

2.0 HARDINGE HARDINGE CNC LATHE SMALL



30

Comment: 1-TURN AS PER FOLIO FA772 &amp; DWG D3811,

FOLIO REV:

DWG REV: PREL

2-DEBURR AS REQUIRED

mmf 08/08/07

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/08/07

4.0 QC8 SECOND CHECK



30

Comment: SECOND CHECK

08.08.07

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



30X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-p 08/08/13

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40987

Part Number: D38113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



**ENGINEERING  
APPROVAL**

*PH 01.08.20*



*30*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*SB 08/08/20*

*30*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/08/20*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*h 08.08.20*

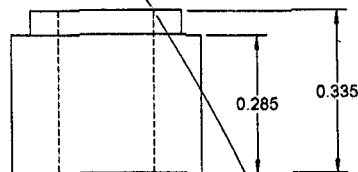
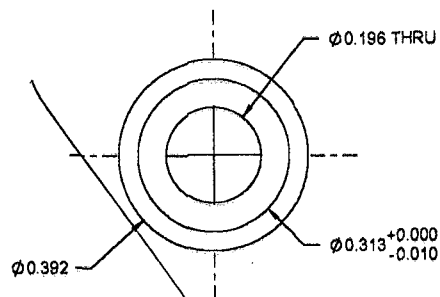
**POSITIVE RECALL**

EFFECTIVE *08/08/05* AUTH *[Signature]*

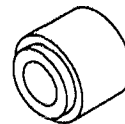
RELEASED *PH* DATE *01.08.20*



w/o 40987



**D3811-3 BUSHING**



PRELIMINARY ISSUE  
08-07-30  
p4

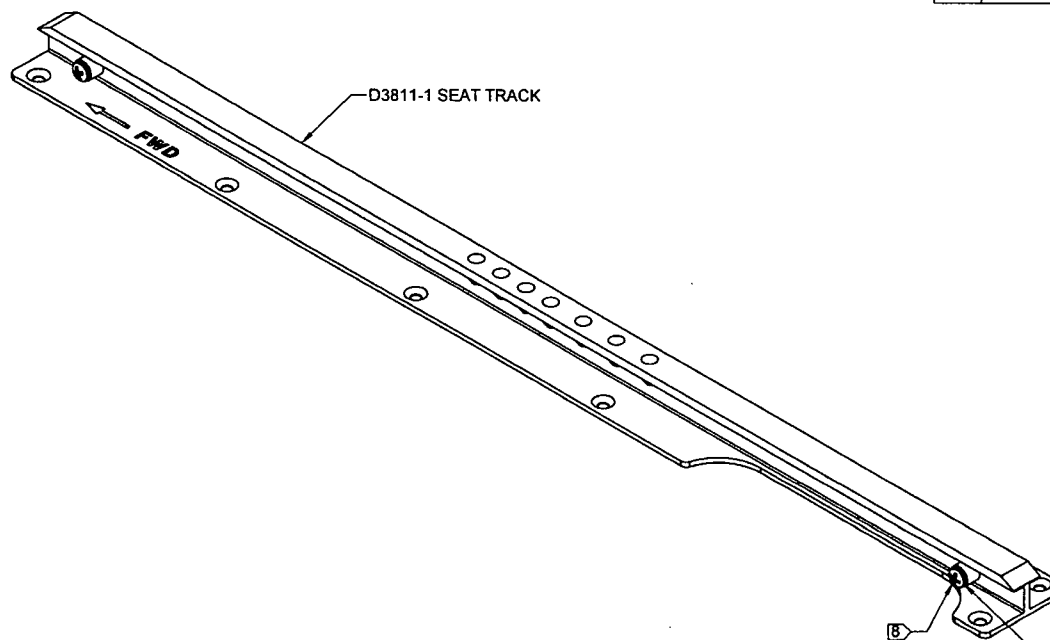
1-772

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (DART REF. SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
DATE	08.07.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED, REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION SYSTEMS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -041	P/N	DESCRIPTION
X	D3811-041	SEAT TRACK ASSEMBLY
1	D3811-1	SEAT TRACK
4	D3811-3	BUSHING
2	MS21042L3	NUT
2	MS27039-1-15	SCREW



**D3811-041 SEAT TRACK ASSEMBLY**

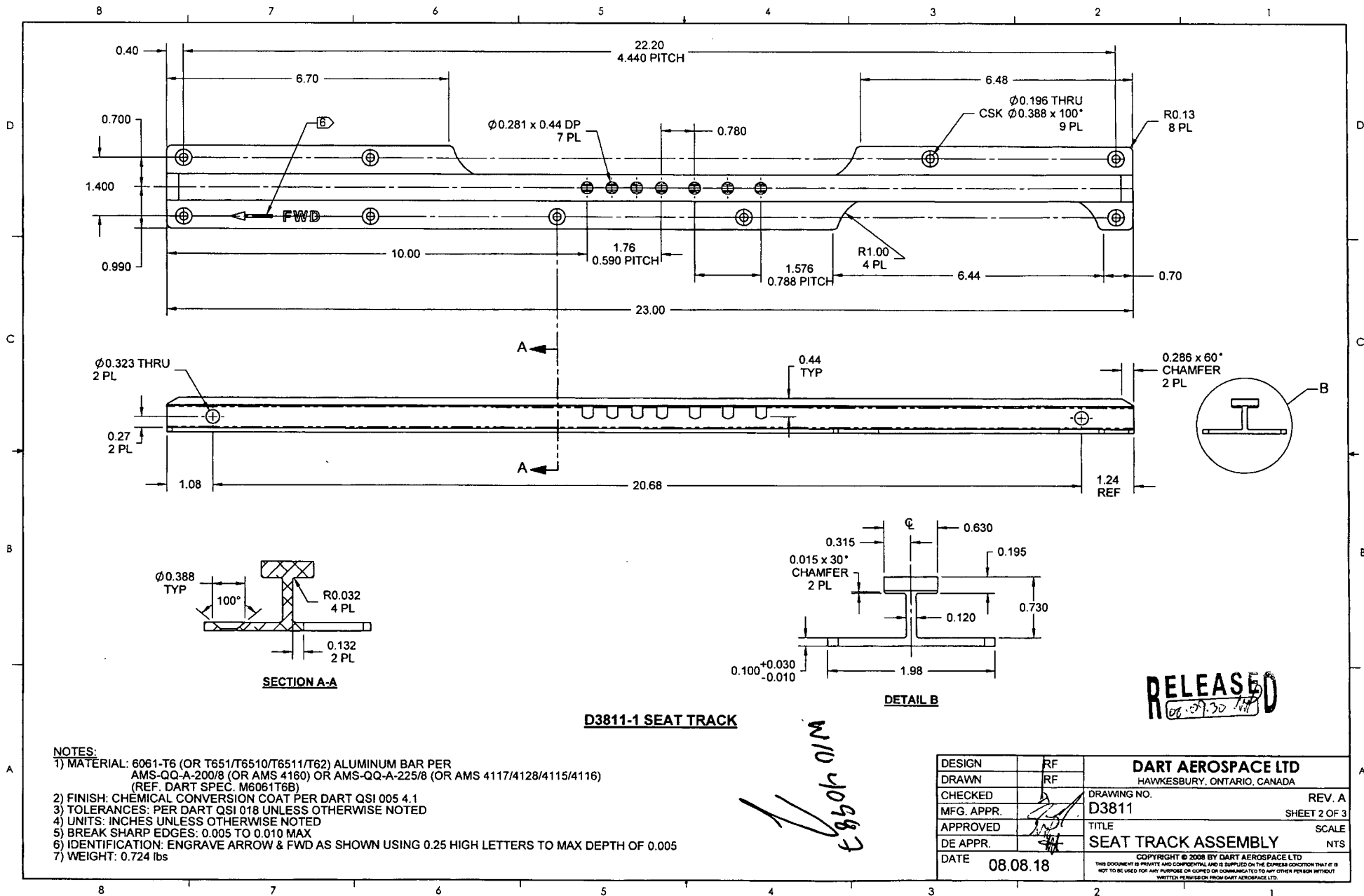
**RELEASED**  
08-08-18

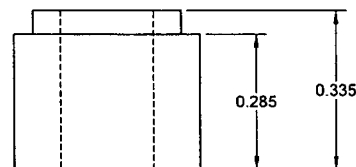
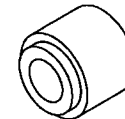
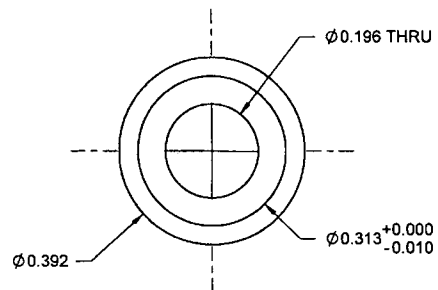
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3811-041 & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE FASTENERS TO 20-25 in-lbs

*W/0 40987*

A	NEW ISSUE	RF	08.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
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# **D3811-3 BUSHING**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (DART REF. SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

*W/D 40987*

**RELEASED**  
08-09-30-16

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. <b>D3811</b>	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>SEAT TRACK ASSEMBLY</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	<b>08.08.18</b>		